

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015670**Date Inspected:** 19-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

Segment 9BW/9CW

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBW9-007, Deck Plate splice. The welder is identified as #045143 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231T-1.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBW9B-008, Bottom Plate splice. The welder is identified as #066326 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBW9B-009, Side Plate splice. The welders are identified as

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#066413, 067904, 037743 and were observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

Segment 9BW

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as SSD25-PP75-125, 126, Partial Height Diaphragm to FL3 Bottom Panel. The welder is identified as #045280 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as SSD25-PP75-157, 158, Partial Height Diaphragm to FL3 web. The welder is identified as #207456 and was observed welding in the 3F (vertical) position using approved Welding Procedure Specification WPS-B-T-2133.

Segment 9CE/9DE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBE9C-004, Side Plate splice. The welder is identified as #067571 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

Segment 9DE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG056A-045, Side Plate to Bottom Plate CJP hold back weld. The welder is identified as #067829 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-FCM-1.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as BP127-001-053, 054, Bottom Plate WT stiffener hold back weld. The welder is identified as #068493 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132.

Segment 9DE/9EE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as BP127-001-020, Bottom Plate WT stiffener web splice. The welder is identified as #068493 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233T.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as DP713-001-020, Deck Plate I-rib splice. The welder is identified as #066155 and was observed welding in the 3G (vertical) position using approved Welding Procedure

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Specification WPS-B-T-3213-B-U3b.

Segment 9EE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as BP128-001-035, 036, Bottom Plate WT stiffener hold back weld. The welder is identified as #068493 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132.

For the above mentioned welding activities ZPMC Quality Control (QC) Inspectors are identified as Wang Li Yang, Liu Hua Jie and Wang Zhu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 9CE/9DE

This QA Inspector observed ABF personnel performing Ultrasonic Testing on the Deck Plate to Edge Plate hold back CJP weld, bike path side.

Segment 9DW

This QA Inspector observed the fit up of the Partial Height Diaphragm at panel points 81 - 82.

BK1-043

This QA Inspector observed heat straightening of BK1-043 bottom panel at Side Plate bolted connection location at weld BK001-043-006 following HSR1(B)-8834.

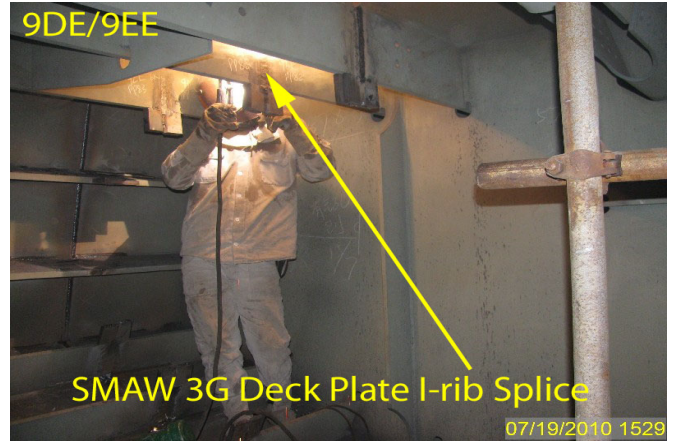
Lift 8 East

This QA Inspector observed lift 8 East was loaded on to the ship for transport to CA.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By: Hernandez,Dan

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer